

Work Order ID 120599

June-05-14 10:17:07 AM

120599

Ship June 9

Page 1

Item ID: D4640-15

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Ceiling Protector

Start Date: 6/05/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/05/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-06-05

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4640

D

100

0.00

DAS

100

23

Waterjet

9-89 14-06-8

FLOW CNC Waterjet

Memo

0.00

***Confirm if parts are trimmed or untrimmed prior to cutting ***

Cut as per dwg

Prog Rev: DDwg Rev: D

Trimmed

Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

DAS

QC

23

9-89 14-06-8

Quality Control

Memo

0.00

Work Order ID 120599

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Item ID: D4640-15

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Ceiling Protector

Start Date: 6/05/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 6/05/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check 0.00

120

0.00

JUN 14/6/14

QC

Memo

Quality Control

USE TEMPLATE TO MARK HOLE LOCATIONS WITH A FINE POINT
MARKER ON TEXTURED SIDE130 Identify as per dwg & Stock Location: Ship 0.00

130

0.00

DAS
28
9-89

1X

JUN 09 2014

Packaging

Memo

Packaging

140 QC21- Final Inspection - Work Order Release 0.00

140

0.00

MLJ 1406-10

QC

Memo

Quality Control

H14-6-9

Picklist Print

June-05-14 10:17:12 AM

Page 1

Work Order ID: 120599

120599

Parent Item: D4640-15

D4640-15

Parent Item Name: Ceiling Protector

Start Date: 6/05/14

Required Date: 6/05/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.05.08 NEW ISSUE DD VERF:EC
12.10.17 AS PER REV.B VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased		No		100	sf	1,165.443	16	17			DAS 23 9-88

MI FXS 093-F6006-07

GE PLASTICS LEXAN SHEET (Grey)

**

1460-8

Location

Loc Qty

Loc Code

MAT023

1165.44332

114459

229.26

123105

38

124501

543.5

m128668

181.35

m129014

173.33332

129014

DART AEROSPACE LTD		Work Order:	120599
Description: Ceiling Protector		Part Number:	D4640-15
Inspection Dwg: D4640	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.80	+/-0.030	18.80"	-		T	Jkmo9
22.03	+/-0.030	22.03"	-		T	
20.06	+/-0.030	20.06"	-		T	
13.06	+/-0.030	13.06"	-		T	
3.60	+/-0.030	3.60"	-		V	Jkmo5
8.09	+/-0.030	8.09"	-		V	Jkmo8
20.86	+/-0.030	20.86"	-		T	
3.11	+/-0.030	3.11"	-		V	
7.27	+/-0.030	7.27"	-		V	
5.10	+/-0.030	5.10"	-		V	
4.85	+/-0.030	4.85"	-		V	
13.06	+/-0.030	13.06"	-		T	
1.50	+/-0.030	1.50"	-		V	
5.00	+/-0.030	5.00"	-		V	
57.46	+/-0.030	57.46"	-		T	
82.37	+/-0.030	82.37"	-		T	
Ø8.13	+0.012/-0.001	8.133"	-		V	
6.77	+/-0.030	6.77"	-		V	
5.72	+/-0.030	5.72"	-		V	
6.13	+/-0.030	6.13"	-		V	
2.21	+/-0.030	2.21"	-		V	
0.88	+/-0.030	0.88"	-		V	
7.78	+/-0.030	7.78"	-		V	
7.47	+/-0.030	7.47"	-		V	
Ø0.375	+0.006/-0.001	0.377"	-		V	
9.73	+/-0.030	9.73"	-		V	
21.00	+/-0.030	21.00"	-		T	
31.28	+/-0.030	31.28"	-		T	
4.00	+/-0.030	4.00"	-		V	
27.23	+/-0.030	27.23"	-		T	
22.28	+/-0.030	22.28"	-		T	
20.36	+/-0.030	20.36"	-		T	
0.093	+/-0.010	0.094"	-		V	

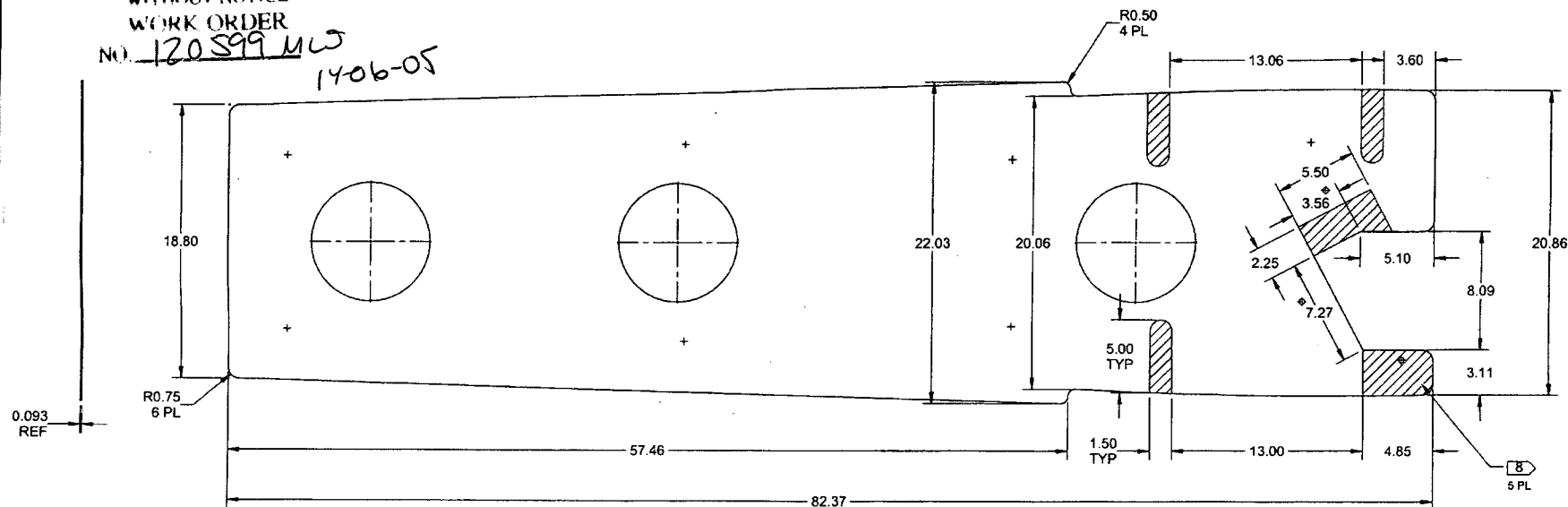
Measured by:	23 9-89	Audited by:	27 9-89	Preliminary Approval:	
Date:	14-06-8	Date:	14/6/9	Date:	

Rev	Date	Change	Revised by	Approved
A	12.09.26	New Issue	KJ	
B	13.02.27	Dwg Rev updated	KJ	

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 120 S99 MLJ
1406-05



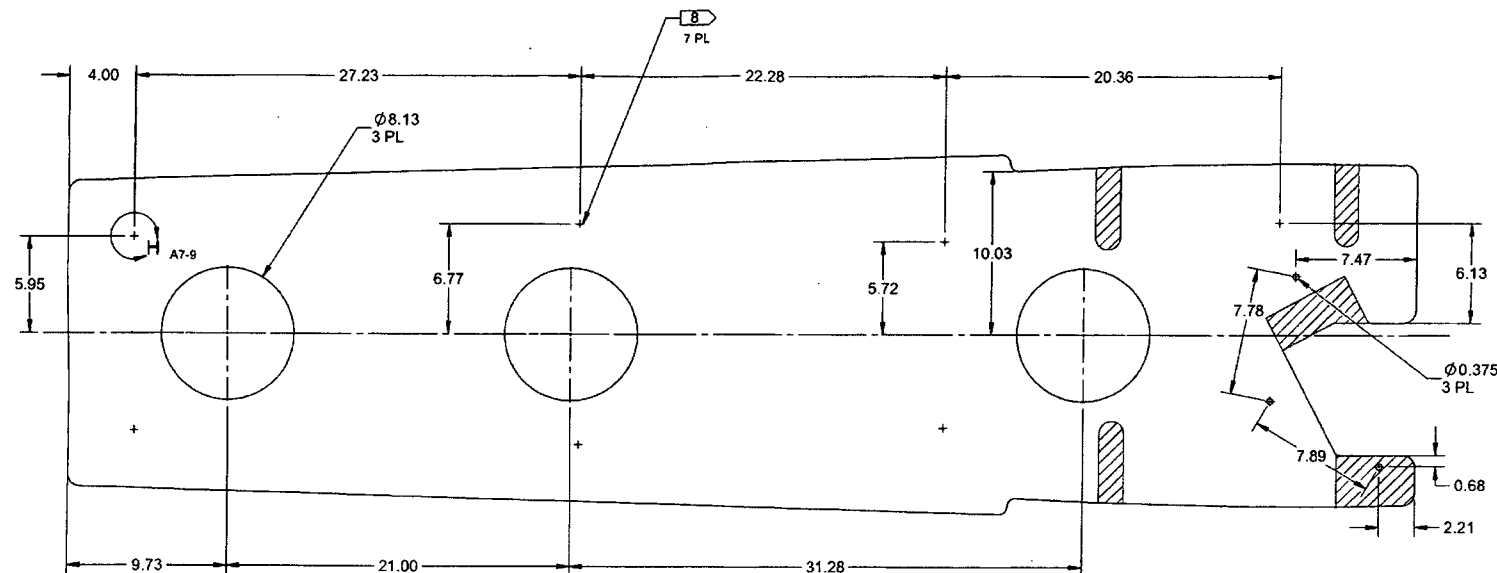
D4640-15 CEILING PROTECTOR
TEXTURED SIDE SHOWN

RELEASED
2013-01-10

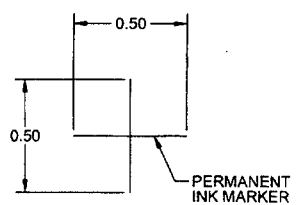
NOTES:

- 1) MATERIAL: F6006-GY5B133 GRAY LEXAN SHEET (SUEDE/POLISHED) 0.093 THICK
REF DART SPEC MLEXX.093-F6006-07
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 5.99 lbs (TRIMMED WEIGHT = 5.78 lbs)
- 8) IF CUSTOMER REQUESTS "TRIMMED KIT" ON PURCHASE ORDER:
- DRAW 0.50" CROSS ON TEXTURED SIDE AT INDICATED LOCATIONS USING PERMANENT INK MARKER
- TRIM AND REMOVE SHADED AREAS

DESIGN	XDF	DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO. D4640	REV. D
MFG. APPR.	JP	SHEET 8 OF 9	
APPROVED	JP	TITLE BAGGAGE PROTECTOR	SCALE
DE APPR.	JP	NTS	
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**D4640-15 CEILING PROTECTOR
SUPPLEMENTAL VIEW**



DETAIL H C7-9
NOT TO SCALE
TRIMMED KIT ONLY

RELEASED
2013-01-10

DESIGN	XDF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>	DRAWING NO. D4640	REV. D
CHECKED	<i>[Signature]</i>		SHEET 9 OF 9
MFG. APPR.	<i>[Signature]</i>	TITLE BAGGAGE PROTECTOR	SCALE NTS
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